

20A6-12

Work Order ID 162331

Friday, June 02, 2017 10:28:18 AM

162331

Page 2

Item ID: D4727-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Barrel
Start Date: 6/2/2017 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 6/12/2017 Req'd Qty: 12.00 ***12*** Customer:
Reference: (P.A.)SCHEDULED/S

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.24				12	0		DAS 44 9-89 17-06-12
140 *140* Small Fab Small Fab	Memo ASSEMBLE INSERT IN BARREL AS PER DWG	0.00 0.46				12x			DAS 36 9-89 17/06/14
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.24				12			DAS 38 9-89 JUN 14 2017

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>5H21</u>	0.00							
160						12	DAS		JUN 15 2017
Packaging	Memo	0.12					6		
Packaging							9-89		
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	1.20							
Quality Control									

DAS
21
9-89

JUN 15 2017

Picklist Print

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1514

Page 1

Work Order ID: 162331

162331

Parent Item: D4727-041

D4727-041

Parent Item Name: Barrel

Start Date: 6/2/2017

Required Date: 6/12/2017

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV:A 12.10.17 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R0.500		Purchased	No			110	f	10.0000	0.054	0.682105			

M303R0 500

303 Round Bar 0.500"

**

Location

Loc Qty

Loc Code

MAT021

10

m137513

10

MS21209F1-15

Purchased

No

140

Each

325.0000

1

12

MS21209F1-15

HELI COIL

**

Location

Loc Qty

Loc Code

ST297

325

m129682

155

m130626

37

m130799

133

DAS

45

9-89

2077612

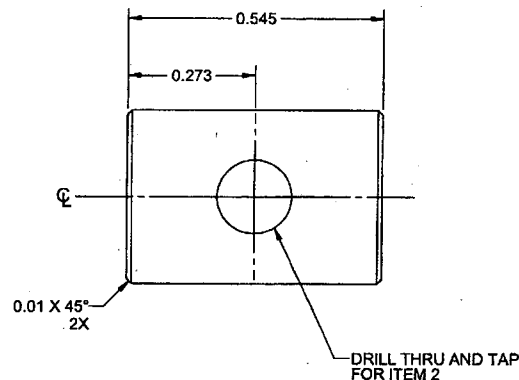
0.724

17/06/14

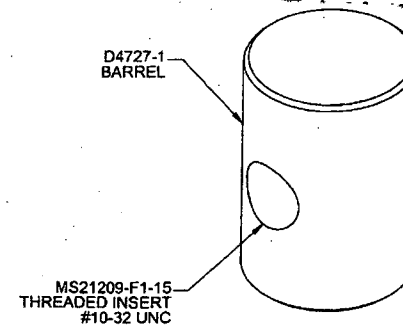
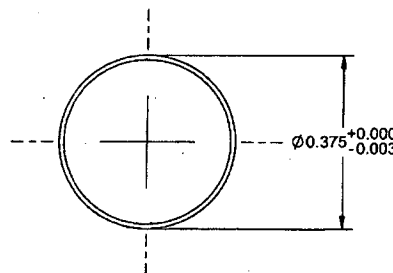
DAS
36
9-89

12

ITEM	QTY	P/N	DESCRIPTION
	X	D4727-041	BARREL
1	1	D4727-1	BARREL
2	1	MS21209-F1-15	THREADED INSERT, #10-32 UNC



D4727-1 BARREL



D4727-041 BARREL

NOTES:

- 1) MATERIAL: AISI 303 SS ROUND BAR PER ASTM A582
REF DART SPEC M303R1.000 OR
AISI 304/316 SS ROUND BAR PER ASTM A276
REF DART SPEC M304R1.000
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 162331

PO 20170602

REV.	NEW ISSUE	DESCRIPTION	RP	12.09.19
DESIGN	RP	DART AEROSPACE USA, INC.		
DRAWN	RP	KENT, WA		
CHECKED	AO	DRAWING NO.	REV. A	
MFG. APPR.		D4727	SHEET 1 OF 1	
APPROVED		TITLE	SCALE	
DE APPR.		BARREL	NTS	
DATE	12.09.19	COPYRIGHT © 2012 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor Approval Verification
					QC / QA Coordinator Approval
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

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